

Date: Thursday, 3/13/2008 10:19:03 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	37921			Part Number	D2571	
Estimate Number	10530			Drawing Number	D2571 REV E	
P.O. Number				Project Number	N/A	
This Issue	3/13/2008	S.O. No.		Drawing Revision	E	
Prsht Rev.	NC			Material		
First Issue	/ /	Type	MACHINED PARTS	Due Date	4/4/2008	Qty: 10 Um: Each
Previous Run	37564					
Written By	<u>JL</u> 08/03/13					
Checked & Approved By						
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351.8.25X7.75X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B31389</u> <u>ark 08/03/29</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>37921</u> Double check by: <u>DTP</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <u>ark/JL 08/04/02</u>			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 <u>ark/JL 08/04/02</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>/JL 08/04/02</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number: 37921		Part Number: D2571
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: SECOND CHECK		8.F 08/04/02 (10)
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		M-p 08/04/02 (10)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		F2 08/04/03 (10)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: st 432		P-84/3 08/04/03 (10)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		08/04/08 (10)
Job Completion 		u 08.04.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 37921	
Description: Saddle, Fwd Outboard				Part Number: D2571	
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

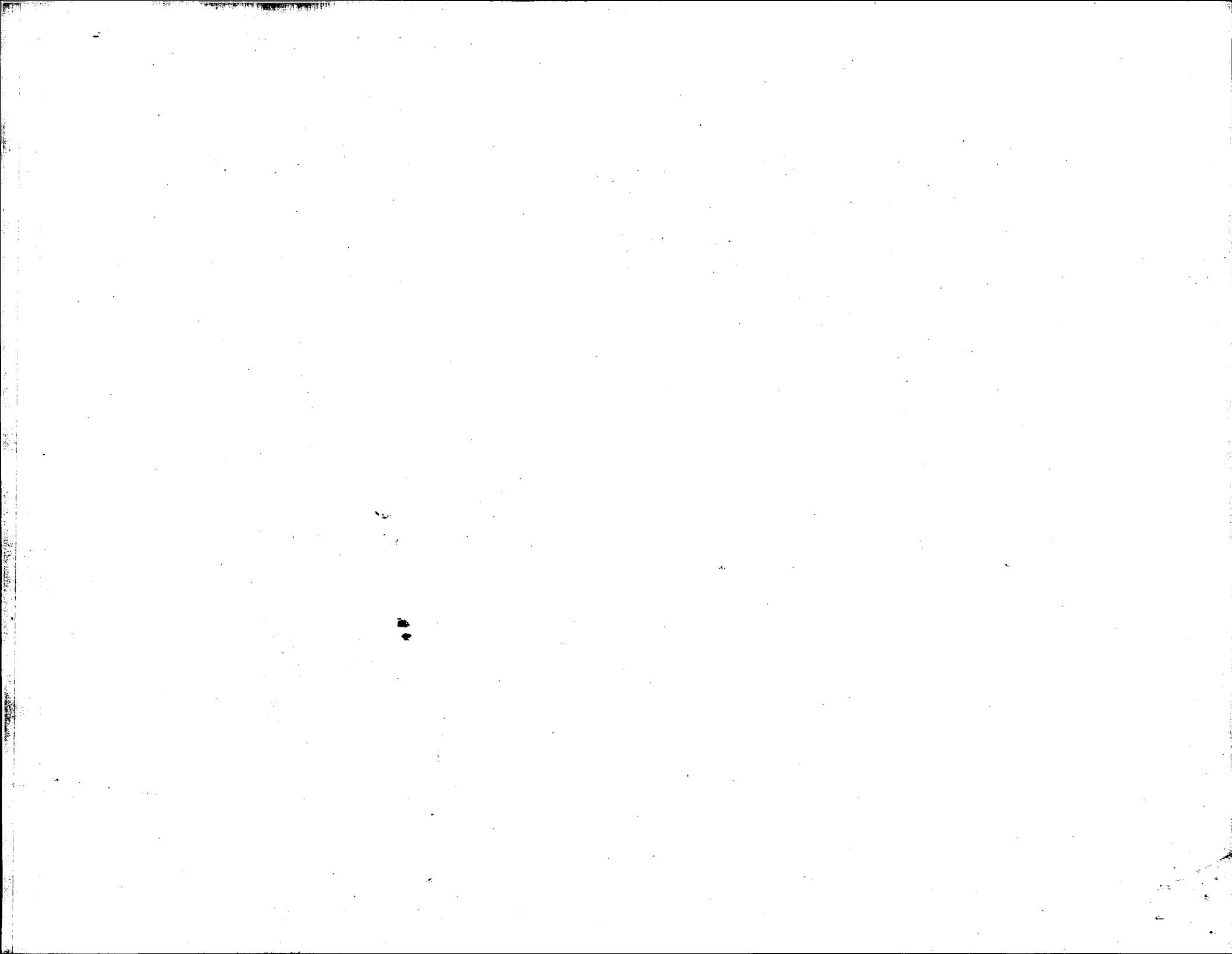
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.506	3.506	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.002	8.002	8.001		
F	0.490	0.510		.500	.502	.503	.499		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.499	.500	.500		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.565	.566	.566	.565		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.490	1.500		1.495	1.496	1.495	1.495		
N	2.495	2.505		2.500	2.506	2.499	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		.124	.124	.125	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.249		
S	0.115	0.135		.134	.132	.133	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.958	2.958	2.958		
V	0.230	0.250		.246	.239	.239	.240		
W	0.115	0.135		.121	.128	.124	.125		
X	0.308	0.313		.309	.309	.309	.308		
Y	0.760	0.765		.766	.766	.766	.760		
Z	0.352	0.372		.362	.361	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.633	.634	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.247	.247	.247		
AE	1.375	1.395	..	1.387	1.386	1.387	1.387		
AF	0.115	0.135		.132	.135	.134	.135		
AG	0.240	0.280		.257	.255	.255	.255		
AH	0.240	0.260		.249	.249	.248	.248		
AI	2.000	2.020		2.002	2.001	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: Mark J.L.
Date: 08/04/02

Audited by: 8-F
Date: 08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JLM</u>



DART AEROSPACE LTD				Work Order:	37921
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		.498	.499	.500	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.568	.568	.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.123	.123	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.250	.249		
S	0.115	0.135		.134	.130	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.958	2.958	2.958		
V	0.230	0.250		.240	.239	.239	.240		
W	0.115	0.135		.128	.123	.123	.120		
X	0.308	0.313		.309	.308	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.365	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.621	.622	.620		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.249	.247	.246		
AE	1.375	1.395		1.387	1.386	1.389	1.388		
AF	0.115	0.135		.132	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.248	.248	.248		
AI	2.000	2.020		2.000	2.000	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: ML/JL
Date: 08/04/01

Audited by: RF
Date: 08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>ML</u> <u>JL</u>

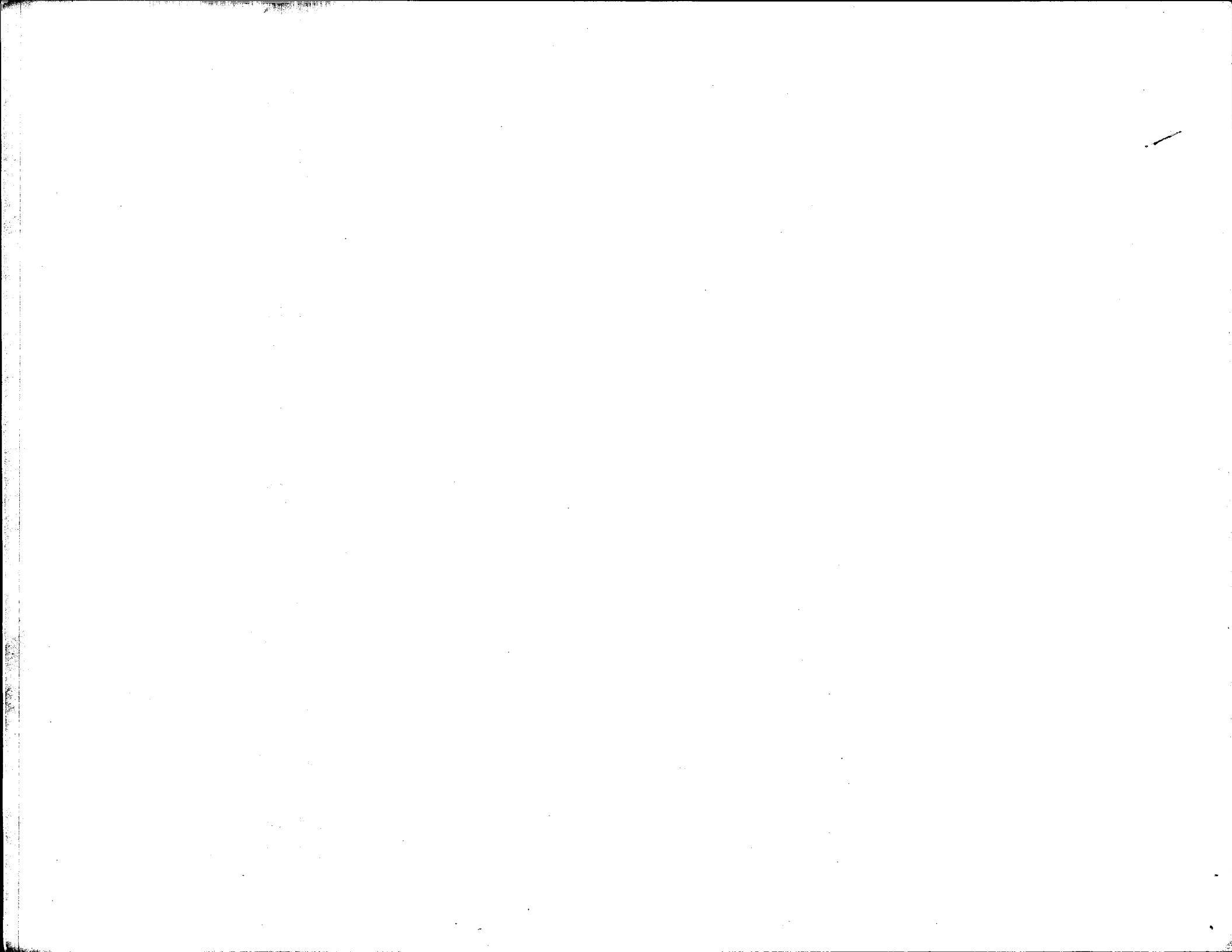
DART AEROSPACE LTD				Work Order:	3792A
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	20	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.000				
F	0.490	0.510		.500	.502				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.502	.502				
J	1.174	1.184		1.171	1.179				
K	0.558	0.578		.569	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.123	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.249	.250				
S	0.115	0.135		.127	.126				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.958				
V	0.230	0.250		.241	.241				
W	0.115	0.135		.124	.126				
X	0.308	0.313		.308	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.362	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.620	.621				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.245	.248				
AE	1.375	1.395		1.389	1.387				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.248	.249				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

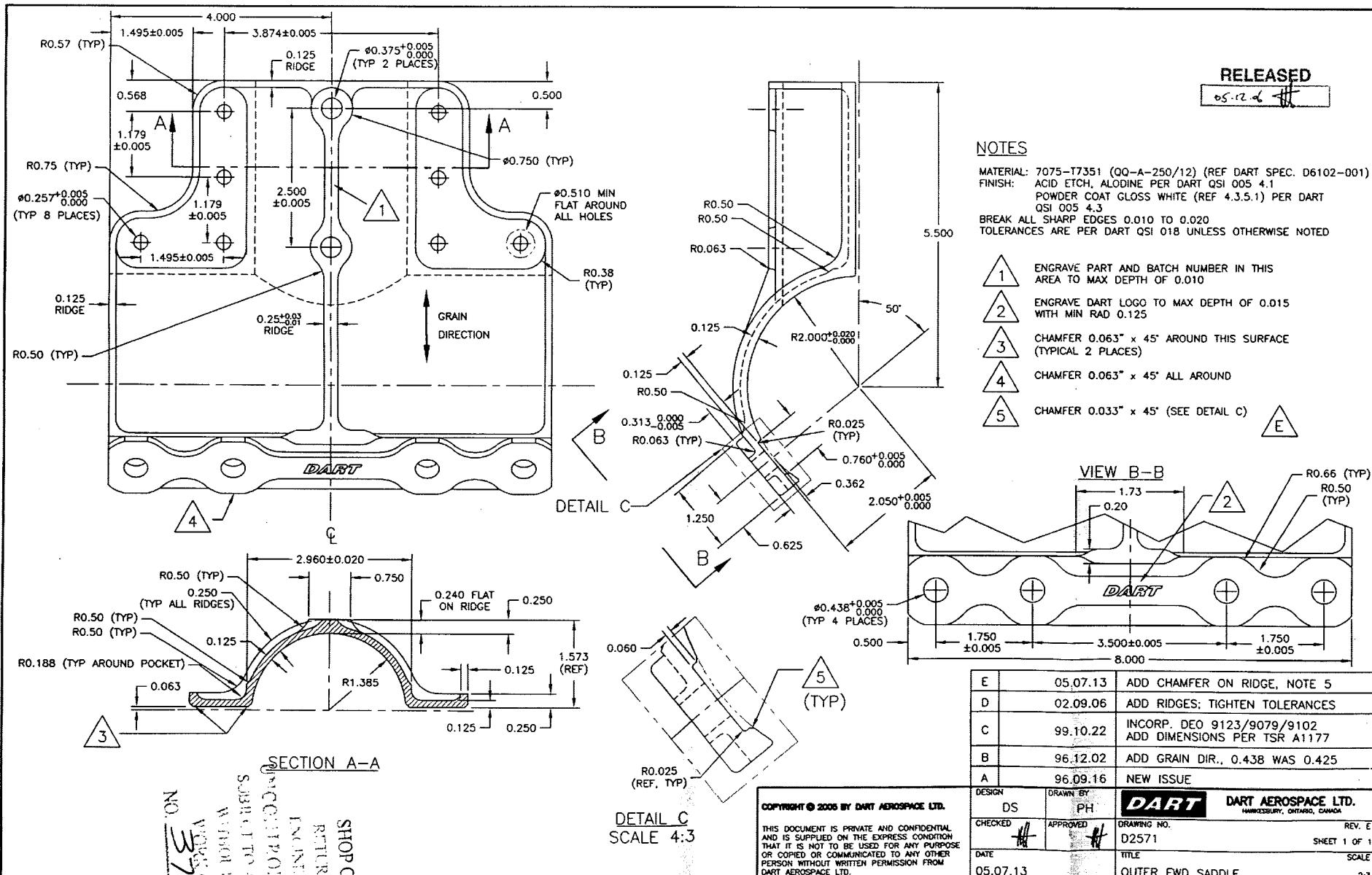
Measured by:	J.L.	Audited by:	8-F
Date:	08/04/02	Date:	08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM



RELEASED

05-12-06



NO. 37421
 1
 SECTION FWD SADDLE
 ENGINEERING
 RETURN TO
 SUBMIT TO
 ENGINEERING
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 NO. 37421
 1
 SECTION FWD SADDLE
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